

Work Order ID 81363

81363

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Item ID: D3537-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 13/03/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	Rev C

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
304 563 Deburr if necessary

N 12.04.01 (24)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

N 12.04.01 (24)

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

5/12/01/02
 (cuts)
 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 13/03/2012 **Start Qty:** 24.00

24

Cust Item ID:

Required Date: 27/03/2012 **Req'd Qty:** 24.00

24

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Debur if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

JB 12/04/03 (24)

140

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

QC

Quality Control

Ensure joggle as per dwg D3429

5/24/03

cents
(724)

150

0.00

150

Large Fab

0.00

Large Fab

Memo

Qty	Description	BatchA/R	2059B Hardcoat
121333	Weld hardcoat as per Dwg D3437		

Large Fab

24

12-04-1992

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC10- Inspect visual per QSI004- ground welds 0.00

160

QC

Memo

0.00

Sizkulis

Quality Control

170 QC5- Inspect part completeness to step on W/O 0.00

170

QC

Memo

0.00

Sizkulis

Quality Control

180 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

180

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

10:20

0.00

3200F

10:50

conts
(x24)

24x ✓

m.f
12/04/20

M117338

W/O:		WORK ORDER CHANGES					
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Item ID: D3537-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearpad

Stop ***NS2***

Start Date: 13/03/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

24 0 BR 12-4-21

200

Identify as per dwg & Stock Location: FP-2

0.00

200

Packaging

Memo

0.00

Packaging

24 0 BR 12-4-21

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/4/23

11/12-04-23

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81363

81363

Parent Item: D3537-3

D3537-3

Parent Item Name: Wearpad

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	254.4860	0.149	3.764211			

M304S16GA

**

304/316 Sheet .063

m 12:01:01

Location

Loc Qty

Loc Code

MAT020

254.486

119653

17.35

120866

78

120877

159.136

B# 121070

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Dart Aerospace Ltd

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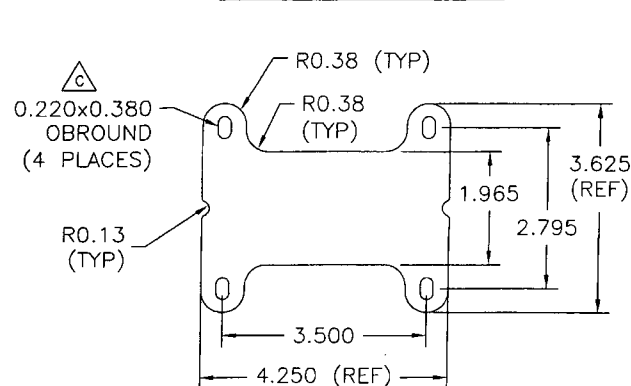
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

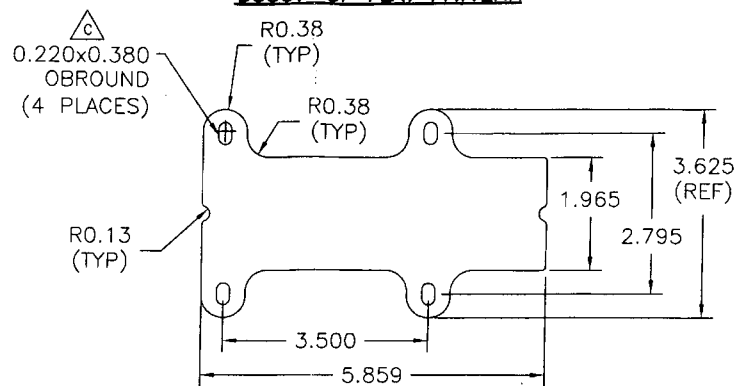
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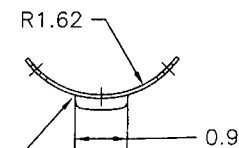
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

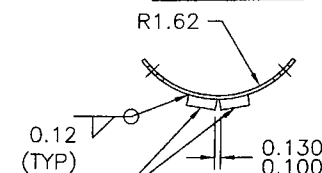


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

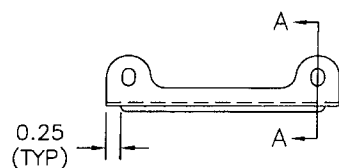
SECTION B-B



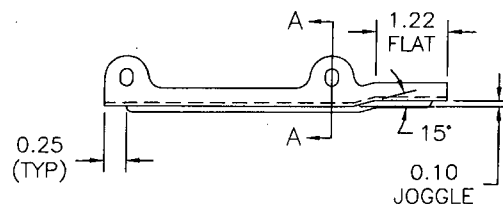
D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
07-05-08
REV ECU
962

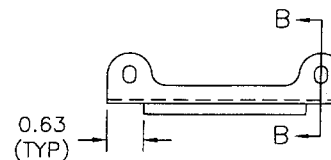
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



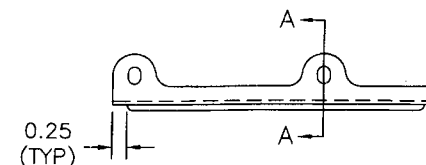
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

SHOP COPY

RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81363 MLC
12/03/13

W/O:		WORK ORDER CHANGES					
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